

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011591**Date Inspected:** 05-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #13

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 11CW, weld No. SSD14A-PP103-227. The welder is identified as #044801. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-U5-F.

FCAW in the 2G position for the OBG Segment 11BW, weld No. SSD12-PP100-226. The welder is identified as #058551. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 3G position for the OBG Segment 11AW, weld No. SEG-065-028. The welder is identified as #051356. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

FCAW in the 2G position for the OBG Segment 11CE, weld No. SSD20-PP103-257. The welder is identified as #044801. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply

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with WPS-B-T-2232-Tc-U4b-F.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as portion of Segment 7DW.

The Weld Designation is as follows

SSD11-PP057-127,133,130,105 and 126

SSD12-PP058-108,133,137 and 130

SEG-039B-042,034,055 and 056

SEG-039A-006,007,008,009,033 and 039

SEG-039-047,024,024 and 023

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) segment 7DW, this Quality Assurance Inspector (QA) discovered that according to approved drawing SEGSD10A the joints were Fillet Weld but as per root gap recorded by ZPMC QC (more than 5mm) the joints should be Complete Joint Penetration (CJP) joints but the QA Inspector found that joints are not CJP welds. The welds are identified as: SSD10A-PP56-148/149 and SSD10A-PP56-150/151. Located at Panel Point 56(PP56) at crossbeam Side. The weld is designated as Seismic Performance Critical Material (SPCM). The welds are "T" joint joining FB19 Plate X12C (SPCM) to Stiffener RS62BB (Non SPCM).

This QA Inspector generated an incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera, Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
